

# Work Order ID 71702

Tuesday, April 24, 2012 12:44:20 PM

**\*71702\***

Page 1

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 7/7/2011 Start Qty: 6.00

Required Date: 8/5/2011 Req'd Qty: 6.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

**\*6\***

**\*6\***

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2341

Rev F

D2360

Rev D

100

0.00

**\*100\***

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.65" Long

25 12-04-25 (Y6)

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2341 and Dwg D2341  
2-Debur

on 12/04/28

6 2

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 7/7/2011      **Start Qty:** 6.00      **\*6\***

**Cust Item ID:**

**Required Date:** 8/5/2011      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:**      **Date:**      **Tooling:**      **Date:**

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00

on 12/04/28

**\*120\***

QC

## Memo

0.00

## Quality Control

130

QC8- Inspect parts - second check

0.00

SL 12-04-30

**\*130\***

QC

## Memo

0,00

## Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

## Memo

0.00

## Hand Finishing

⑥ 76 12-51

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Item ID: D2360

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Litter Tie Down Assembly

Start Date: 7/7/2011 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b> Powdercoat Powder Coating						6X	0		M/L 12/05/07
	Memo: 3-45 START TIME: _____ OVEN TEMPERATURE: 320 F FINISH TIME: 4:15	0.00							
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b> QC Quality Control						6	0		BLD-5-2
	Memo	0.00							
170	Small Fab	0.00							
<b>*170*</b> Small Fab Small Fab						6x			12/05/10
	Memo Assemble as per dwg D2360	0.00							

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Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 7/7/2011 Start Qty: 6.00

Required Date: 8/5/2011 Req'd Qty: 6.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\*****\*6\***

Cust Item ID:

**\*6\***

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

190

Identify as per dwg &amp; Stock Location

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

Srloly

(de)

(bx)

SP

A-5-17.

12/5/17 JJ

ME

12-05-17

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Work Order ID: 71702

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 7/7/2011

Required Date: 8/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R18 - Screw		Purchased	No			170	Each	654.0000	1	6		5/12/05/16	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FP002		93							
				4523		93							
				ST348		561							
				101458		42							
				108079		419							
				110099		100							
AN960JD10 Washer	NAS1149D0363J	Purchased	No			170	Each	0.0000	2	12		5/12/05/16	
AN960JD10L Washer	NAS1149D0332J	Purchased	No			170	Each	0.0000	8	48		5/12/05/16	
D2002-015 Knob		Manufactured	No			170	Each	25.0000	2	12		5/12/05/16	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz		23							
				16177		23							
				ST002		2							
				78981		2							
D2345 Lock Channel		Manufactured	No			170	Each	18.0000	1	6		5/12/05/16	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST011		18							
				70800		18							
D2366 Lock Handle		Manufactured	No			170	Each	25.0000	2	12		5/12/05/16	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST008		25							
				73333		25							

AN960JD10  
Washer  
AN960JD10L  
Washer  
D2002-015  
Knob

NAS1149D0363J  
Purchased  
M120644  
NAS1149D0332J  
Purchased  
M119717  
Manufactured

No  
120  
No  
480  
No

Location  
Mezz  
16177  
ST002  
78981

Loc Qty  
23  
23  
2  
2

Loc Code

B 83450  
102

2

6

12

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Work Order ID: 71702

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 7/7/2011

Required Date: 8/5/2011

Start Qty: 6.00

Required Qty: 6.00

D2367 Manufactured No

170 Each 10.0000

1

6

Handle Knob

Location

Loc Qty

Loc Code

ST008

10

68883

10

D2372 Manufactured No

170 Each 30.0000

2

12

Quick Release

Location

Loc Qty

Loc Code

ST

30

80274

2

80510

28

D2373 Manufactured No

170 Each 10.0000

1

6

Spring

Location

Loc Qty

Loc Code

ST008

10

66118

10

D2444 Manufactured No

170 Each 19.0000

1

6

Pip Pin Assembly

Location

Loc Qty

Loc Code

ST009

3

80060

3

ST019

16

79477

16

D6201 Manufactured No

100 f 15.0400

1.054

6.6568421

"T" Extrusion

Location

Loc Qty

Loc Code

MAT004

2.04

57767

1.34

71208

0.7

MAT28

13

77491

12

81421

1

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Work Order ID: 71702

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 7/7/2011

Required Date: 8/5/2011

Start Qty: 6.00

Required Qty: 6.00

MS20470AD3-4  
Rivet, Universal Head

Purchased No

170 Each 8,613.0000 1 6

Location	Loc Qty	Loc Code
ST319	8613	
111477	8332	
15541	281	

MS21042L3  
Nut

Purchased No

170 Each 3,521.0000 3 18

Location	Loc Qty	Loc Code
ST300	3521	
117441	16	
117885	32	
118451	5	
118927	3	
119017	1387	
119075	158	
121349	920	
1214444	1000	

MS27039-1-13 -  
Screw

Purchased No

170 Each 115.0000 1 6

Location	Loc Qty	Loc Code
ST291	115	
110844	15	
119736	100	

MS27039-1-15  
Screw

Purchased No

170 Each 74.0000 2 12

Location	Loc Qty	Loc Code
ST291	74	
118093	12	
118574	2	
119736	10	
121243	50	

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Work Order ID: 71702

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

NAS679A3W

Nut

Purchased

No

170

Each

208.0000

1

6

Start Date: 7/7/2011

Required Date: 8/5/2011

Start Qty: 6.00

Required Qty: 6.00

*EP 12/05/16*

Location

Loc Qty

Loc Code

GA

15

1463

15

2409

193

6

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71702
<b>Description:</b> Litter Tie Down Bracket (Locking)		<b>Part Number:</b> D2341
<b>Inspection Dwg:</b> D2341	<b>Rev:</b> F	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

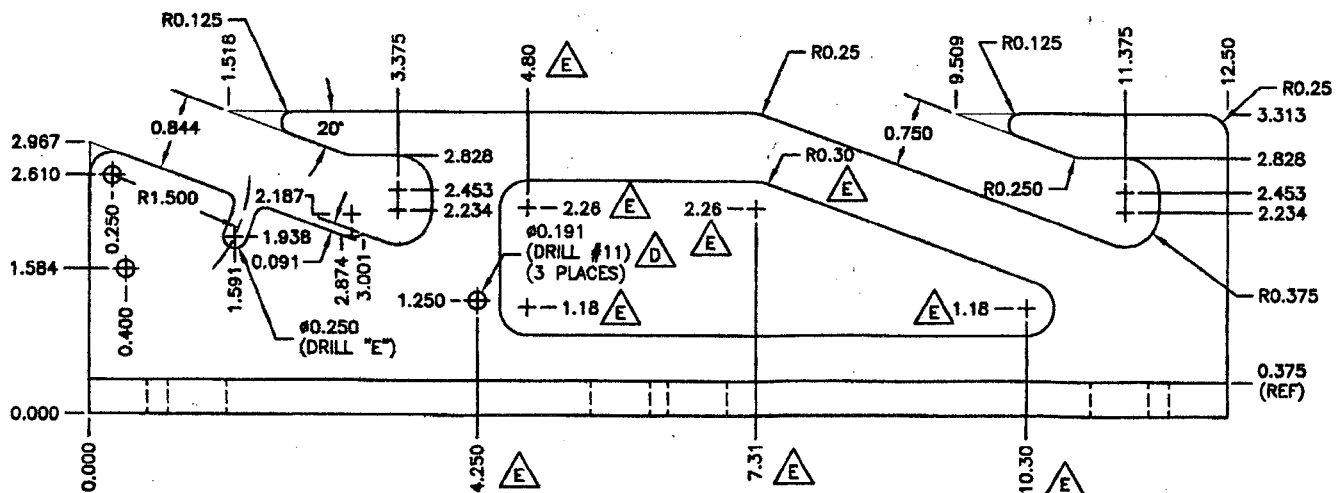
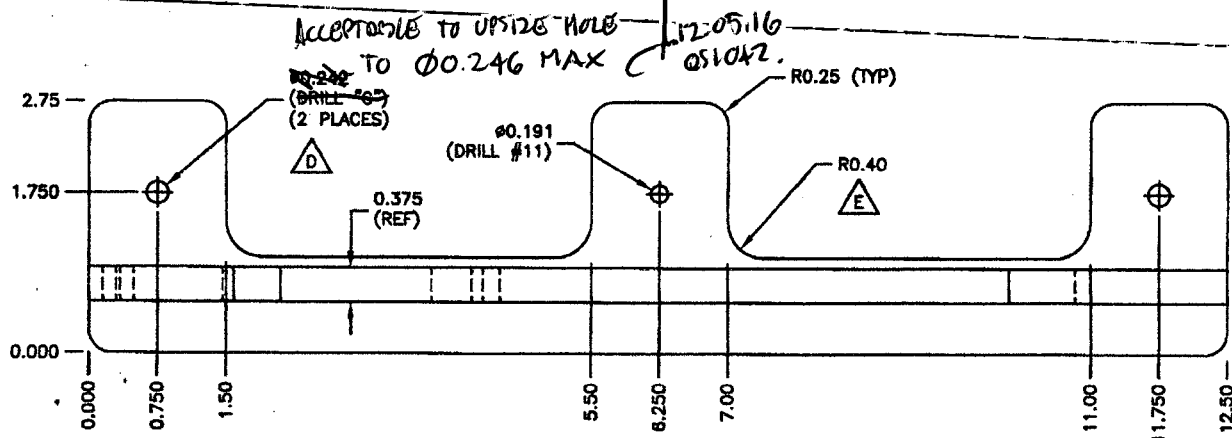
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.746	✓		Vern M1-06	
2.75	+/-0.030	2.754	✓		"	
Ø0.242	+0.005/-0.001	Ø.244	✓		"	
Ø0.191	+0.005/-0.001	Ø.193	✓		"	
R0.25	+/-0.030	R.250	✓		R-L	
R0.40	+/-0.030	R.400	✓		R-L	
12.50	+/-0.030	12.500	✓		M-type M1-04	
11.750	+/-0.010	11.750	✓		"	
11.00	+/-0.030	11.006	✓		"	
7.00	+/-0.030	7.000	✓		"	
6.250	+/-0.010	6.250	✓		"	
5.50	+/-0.030	5.500	✓		"	
1.50	+/-0.030	1.500	✓		"	
0.750	+/-0.010	750	✓		Vern M1-06	
0.400	+/-0.010	.400	✓		"	
1.584	+/-0.010	1.585	✓		"	
2.610	+/-0.010	2.611	✓		"	
0.250	+/-0.010	.250	✓		"	
0.844	+/-0.010	.845	✓		"	
Ø0.250	+/-0.010	Ø.251	✓		"	
0.750	+/-0.010	.756	✓		"	
3.313	+/-0.010	3.314	✓		"	
4.250	+/-0.010	4.250	✓		"	
1.250	+/-0.010	1.250	✓		"	

<b>Measured by:</b> <i>anf</i>	<b>Audited by:</b> <i>J</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 12/04/28	<b>Date:</b> 12-04-30	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	

**DART**

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION  
(6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT  
PERMANENT INK MARKER

**RELEASED**

07-06-22

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DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED

97.06.07

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT



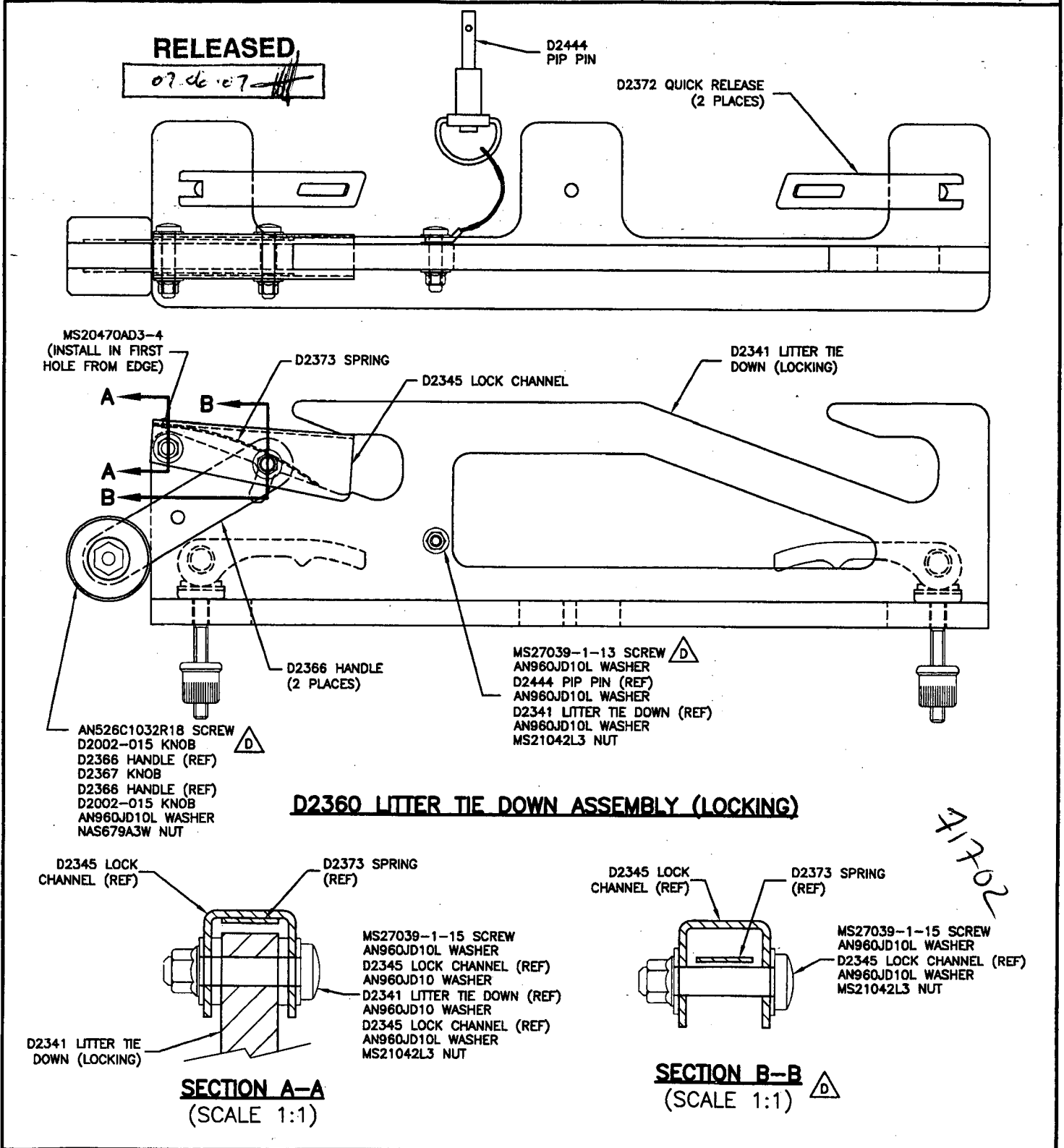
SHOP COPY  
RETURN TO  
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WORK ORDER  
NO. 12/05/05

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DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>#</b>	DRAWING NO. <b>D2360</b>	REV. D SHEET 2 OF 2
DATE <b>07.06.06</b>	TITLE <b>LITTER TIE DOWN ASSEMBLY (LOCKING) NTS</b>		



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